

Work Order ID 55159

January 7, 2010 1:32:40 PM



Page 1

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 07/01/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 10/02/2010 Req'd Qty: 5.00



Customer:

Reference:

Plan Start



Approvals:

Process Plan:

[Signature]

Date:

10-1-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3272	Rev B
-------	-------

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

8/10/02/09

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R ☐ Aluminum Rod ☐ *1111311*

1111494

3-Grind End Plate flush

10-01-27

5 *φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55159

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Item ID: D350-591-311

Accept

Setup Start

Revision ID:

Stop

Item Name: Keli-Access-Step, Long LH

Start Date: 07/01/2010 Start Qty: 5.00

Cost Item:

Required Date: 10/02/2010 Req'd Qty: 5.00

Customer:

Reference:

Ran Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

5 BE 10/01/28

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 8/10/01/28

(544)

140

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12 10.01.28

5 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Item ID: D350-591-311

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Setup Start



Revision ID:

Step



Item Name: Heli-Access-Step, Long LH

Start Date: 07/01/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 10/02/2010 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Step



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Imp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SAD
10-02-01

5

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R Aluminum Rod MILL 311

6-Grind End Plate flush

7-Install last rivet as per Dwg

10-02-02

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Item ID: D350-591-311

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long LH

Start Date: 07/01/2010 Project Qty: 5.00

Cost Item ID:

Required Date: 10/02/2010 1st Q'd Qty: 5.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC9- inspect vizual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

D 10.02.02

200

QC5- inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

=> 81010212

(75.4)

210

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

=> 10.02.04

(VSLH) 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Run Start



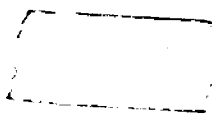
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M113170</i> Memo START TIME: 7:30AM OVEN TEMPERATURE: 320°C FINISH TIME: 8:00AM	0.00 <i>⇒ M 10/02/05</i> 0.00				<i>(X5)</i>	<i>Ø</i>		
230 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M112900</i> Memo	0.00 <i>PK 10-02-8</i> 0.00				<i>(3)</i>	<i>Ø</i>		
240 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 <i>Si 10/02/09</i> 0.00				<i>X5</i> <i>41</i>			



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D350-591-311

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Item Name: Heli-Access-Step, Long L&L

Start Date: 07/01/2010 Start Qty: 5.0

Cast Item ID:

Required Date: 10/02/2010 Req'd Qty: 5.0

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260 	QC4- 100% inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPD350-591-311								
	Location:								

10-2-5

SL (50)

5/10/09

(+5)
44

Rev B

10-2-9

(50) SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55159

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Item ID: D350-591-311

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Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 07/01/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 10/02/2010 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/09

MF

10-2-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 1

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Work Order ID: 55159

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH


Comments: IPP Rev: A 04.03.22 New issue KJ/R
IPP Rev: B 07-06-89 Added D3272 F.M.
IPP returned to CHG001 for Fairweather, NCR08-082 LL verified by: EC

Start Date: 01/01/2010

Required Date: 10/02/2010

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bu/	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3065-041		Manufactured	No				Each	60.0000	5.0000			
												
Step Leg Assembly Hi												

10.02.02

D3066-1		Manufactured	No				Each	102.0000	10.0000			
												
Spacer												

5
10.02.02

D3219-1		Manufactured	No				Each	122.0000	10.0000			
												
Plate												

10
10.01.27

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	14	
	53523	14	
Main Warehouse	WA	46	
	52104	6	
	53795	40	
Main Warehouse	ST	102	
	51545	11	
	53783	91	
Main Warehouse	ST	122	
	53789	122	

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55159

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LM

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: A 04.03.22 New issue KJ/RP

Start Qty: 5.00

Required Qty: 5.00

IPP Rev: B 07-06-09 Added D3272-1 JLM

IPP returned to CHG001 for Euseptor, ref NCR08-082 LL verified by EC

Component Item ID	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3067-1		Manufactured	No			110	Each	113.0000	5.0000			



End Plate

10.01.27

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

113

53784

113

D3272-1

Manufactured No

110

Each

0.0000

5.0000



Step

MS21042L5

Purchased No

110

Each

1,005.000

10.0000



Nut

5

10.01.12 355158

10-2-8

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1005

110382

10

111636

11

112314

484

113523

300

113537

200

10

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55159

Parent Item: D350-591-311

Parent Item Name: Hel-Access-Step, Long LH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: A 04.03.23 New issue KJ/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev: B 07-06-09 Added D3272-1 JLM

IPP returned to CHC for Eurocopter, ref NCR08-082 LL verified by: EC

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS20600-AD4W4		Purchased	No			180	Each	1,683.000	80.0000			



Rivets

10.02.02

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1685
110731	215
111359	45
111477	74
112314	824
112385	24
113368	500

AN3-35A

Purchased

No

260

Each

261.0000 10.0000



Bolt

10-2-5

sp

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	261
106993	12
110467	1
112314	248

10

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 55159

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 07/04/2010

Required Date: 10/02/2010

Comments: IPP Rev: A 04-03-22 New issue KJ/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev: B 07-06-09 Added D3272-1 JLM

IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by: EC

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN4-13A		Purchased	No			260	Each	569.0000	40.0000			



S
+5 Bolt

10-2-8

SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

569

113359

569

17406

0

51764

0

40

AN5-36A

Purchased

No

260

Each

175.0000

10.0000



S
TS Bolt

10-2-5

(SK)

SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

175

109545

11

110467

7

110731

4

112243

20

112314

83

112365

50

10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 55159



Parent Item: D350-591-311



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: A 04-03-22 New Issue OK/RF

Start Qty: 5.00

Required Qty: 5.00

IPP Rev: B 07-06-09 Added DE272-1

IPP returned to CHG001 for Euroceptor, ref CR08-082 LL verified by: EC

Component Item ID/	Replacement	Qty/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD10		Purchased	No			260	Each	998.0000	20.0000			



Washer

NAS 149003634

QSI 07

SL

M 1732 88 10-2-5

32

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

998

105442

8

109059

2

109840

23

110139

2

110985

202

111279

5

111668

48

112314

78

112369

22

113149

608

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 55159

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rec-A 04.03.22 New issue KJRF

Start Qty: 5.00

Required Qty: 5.00

IPP Rec-B 07-06-09 Added D3272-1 JLM

IPP returned to CHG001 for Euroceptor, ref NCR08-082 LL verified by BC

Component Item ID	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD416 4/6		Purchased	No			260	Each	1,489.000	80.0000			

Washer

NA51149004632

QSi 017

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1489

103691

20

104215

6

108161

329

110523

340

111279

101

111916

482

112314

211

16941

0

AN960JD516 4/6

Purchased

No

260

Each

589.0000

20.0000

Washer

NA51149005632

QSi 017

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

589

110363

46

110523

57

111279

39

112082

64

112314

14

112828

18

113149

351

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

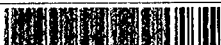
NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55159



Parent Item: D350-591-311



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: A 04.03.22 New issue KJ/RP

Start Qty: 5.00

Required Qty: 5.00

IPP Rev: B 07-06-09 Added D3272-1 JLM

IPP returned to CHG001 for Eurocopter, ref NOR08-062 LL verified by: EC

Component Item ID/	Replacement	Mfg/	Bin	Primary	East	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2230-3 24		Manufactured	No			260	Each	177.0000	20.0000			



Lug

10-2-5

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 7

50306 5

51568 2

Main Warehouse

ST176 100

53881 100

Main Warehouse

ST476 70

53781 70

D2618 Manufactured No



Bushing

121.0000 10.0000

10-2-5

50

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST39 121

50989 121

10

January 7, 2010 1:32:45 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 7, 2010 1:32:45 PM

Work Order ID: 55159

Parent Item: D350-591-311

Parent Item Name: Heli-Acces-Strip, Long LH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev: A 04/03/22 New issue KJ/RF
IPP Rev: B 07-06-09 Med D3272-1 JLM
IPP returned to C78001 Helicopter, ref NCR08-082 LL verified by: EC

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg	Bin	Primary	Last	Route	Unit of	Qty on	Rem	Qty	Date	Status
D2856-400		Manufactured	No			260	f	290.3921	3.0000			



Abraison Strip

marked 720" S. f. 10/2/10

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST403	290.3920842	
	50593	141.312084	
	52563	149.08	

10-2-5

✓

D3067-1

Manufactured No



End Plate

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	113	
	53784	113	

✓

10-02-02

D3235-1 XZ

Manufactured No



Mounting Lug

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	35	
	45398	4	
	53785	31	

5

1354786 10-2-55/ 5x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January 7, 2010 1:32:45 PM

Work Order ID: 55159

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev:A 04.03.22 New issue OKJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by EC

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3278-041		Manufactured	No			260	Each	53.0000	5.0000			



Support Assembly

10-2-5

SK

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

53

52075

13

53227

40

260

Each

2,916.000 10.0000

5

10-2-5

SK

MS21042L3

Y2



Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2916

110844

35

111274

27

111668

52

112314

1302

112385

500

113523

300

113537

700

10

January 7, 2010 1:32:45 PM

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10

January 7, 2010 1:32:45 PM

Work Order ID: 55159

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH


Start Date: 07/01/2010

Required Date: 10/02/2010

Comments: IPP Rev:A 04.03.22 New issue K1/RF
 IPP Rev:B 07-06-09 Added D3272-1 ALM
 IPP returned to CHG001 for Eurocopter, ref NCR08-002 LL verified by:EC

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L4 ✓		Purchased	No			260	Each	4,009.000	40.0000			
<div><div></div><div><div>S 45 Nut</div><div>16-2-5</div><div>OK</div><div>SP</div></div></div>												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	4009	
102552	6	
104248	6	
110507	184	
111827	2813	40
113422	1000	
15924	0	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>ep</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NT6
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005.4.3
BLACK ANTI-SKID PAINT PER DART QSI 005.4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *55159*

10-1-07

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

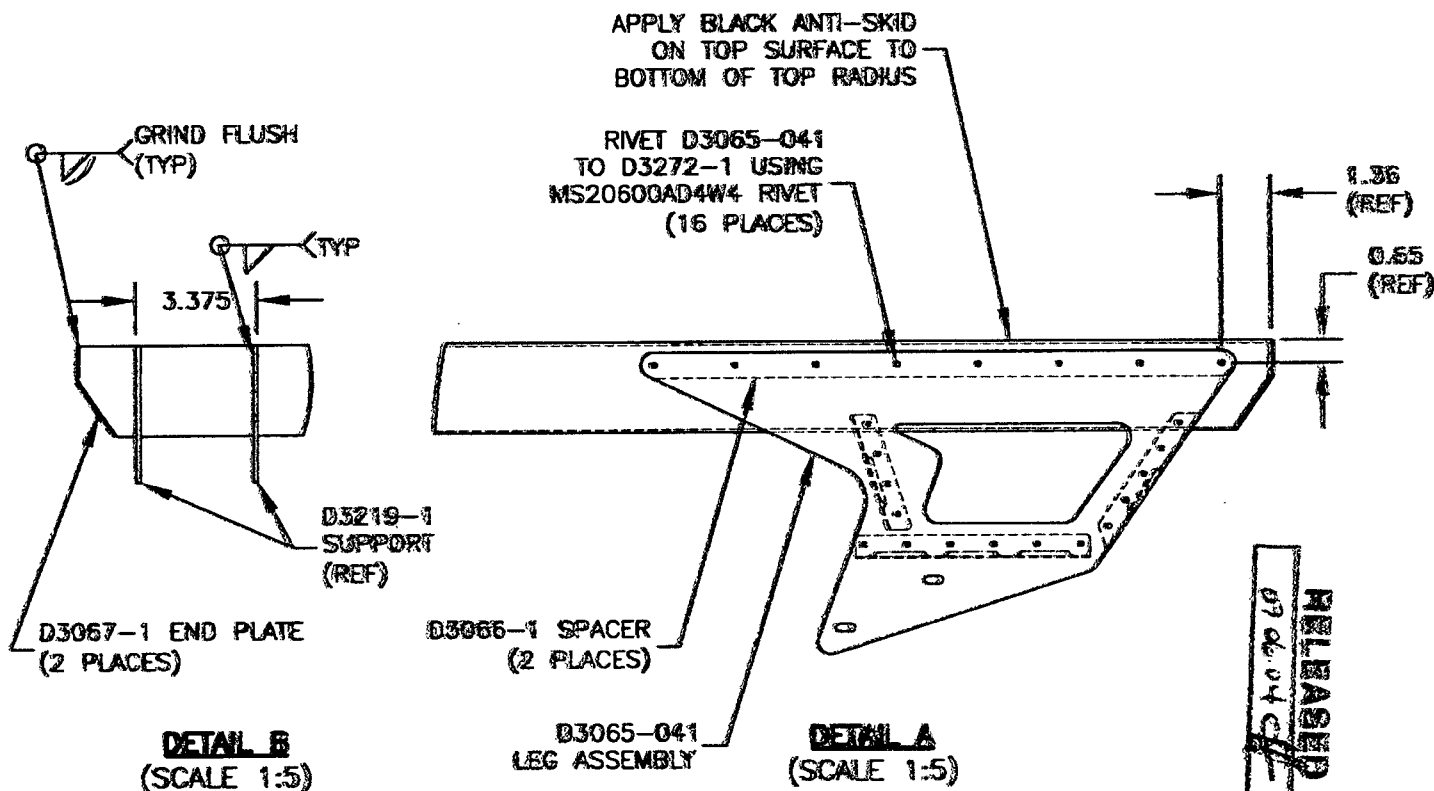
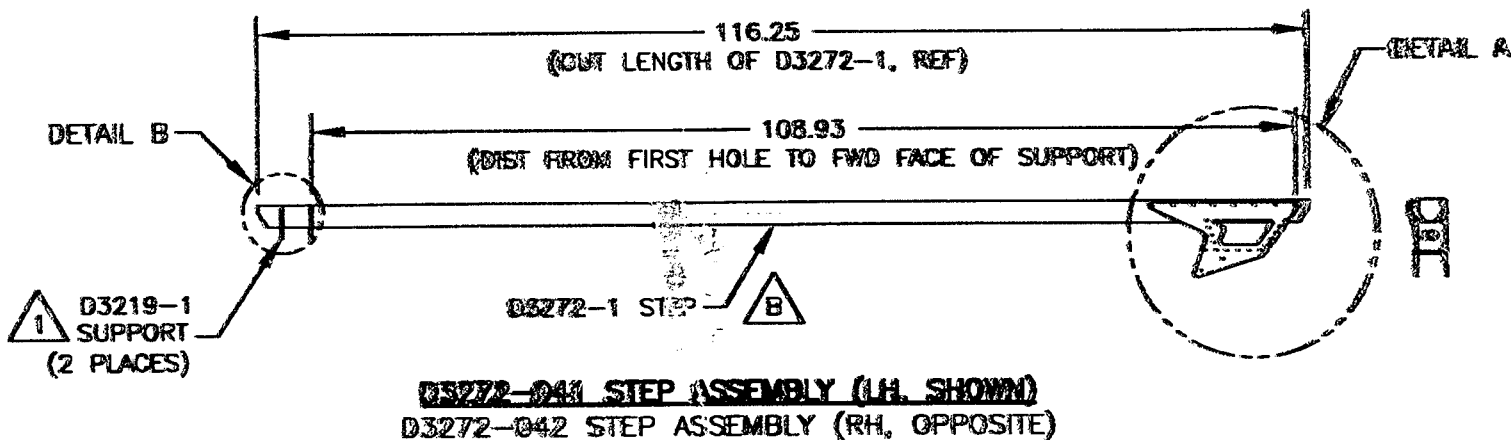
NOTE: Date & initial all entries

DART

DESIGN	90	DRAWN BY	10	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	Le	APPROVED	10	REV. B
DATE	07.05.18	DRAWING NO.	D3272	SHEET 2 OF 3
		TITLE	STEP ASSEMBLY, HI LONG	SCALE
				1:20

11/5 55159

RELEASED
07.06.04



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

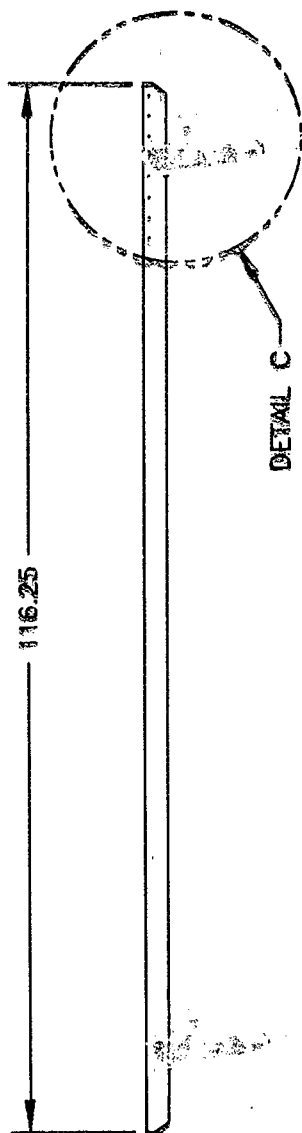
NOTE: Date & initial all entries



DESIGN QP	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

RELEASED

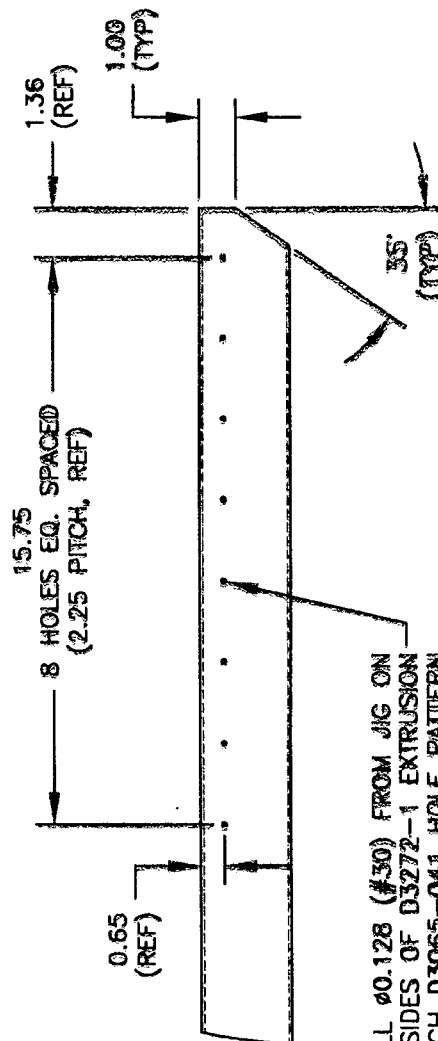
07.06.04 [Signature]



DETAIL C

△ D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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